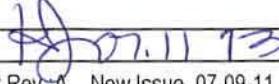


Date: Tuesday, 11/13/2007 1:24:08 PM
User: Kim Johnston

Split Sb 07/12/20

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: ACCESS PANEL ASSEMBLY		
Job Number	: 35649-1			Part Number	: D3245041		
Estimate Number	: 13008			Drawing Number	: D3245 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 11/13/2007 S.O. No. :			Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 11/28/2007 Qty: 6 Um: Each		
Previous Run	: 34551			6			
Written By	:			72			
Checked & Approved By	:  07.11.13			8			
Comment	: Est Rev:A New Issue 07-09-11 JLM Verified By:EC						
	: Est Rev:b ECN 1052 07-10-31 DD verified by: EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1
		Comment: PACKAGING RESOURCE #1 Pick Packing Kit
2.0	D32451	Panel
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Panel Batch: <u>B 35658</u> Sb 08/12/15 (12)
3.0	D32455	Angle Plate
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Angle Plate Batch: <u>B 35047 x 6</u> <u>B 35067 x 6</u> AS 02/12/19 (12) V12
4.0	235018C3Y	RIGID RECEPTACLE
		Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s) RIGID RECEPTACLE Batch: <u>M 106037</u> m105729 x 16 (16) m196810 x 32 (12) AS 02/12/19 (12) V12
5.0	MS20427M33	Rivet
		Comment: Qty.: 16.0000 Each(s)/Unit Total : 96.0000 Each(s) Rivet Batch: <u>M 106037</u> <u>M 105940 x 96</u> <u>AS 02/12/19</u> (12) V12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/13/2007 1:24:08 PM
User: Kim Johnston

Process Sheet

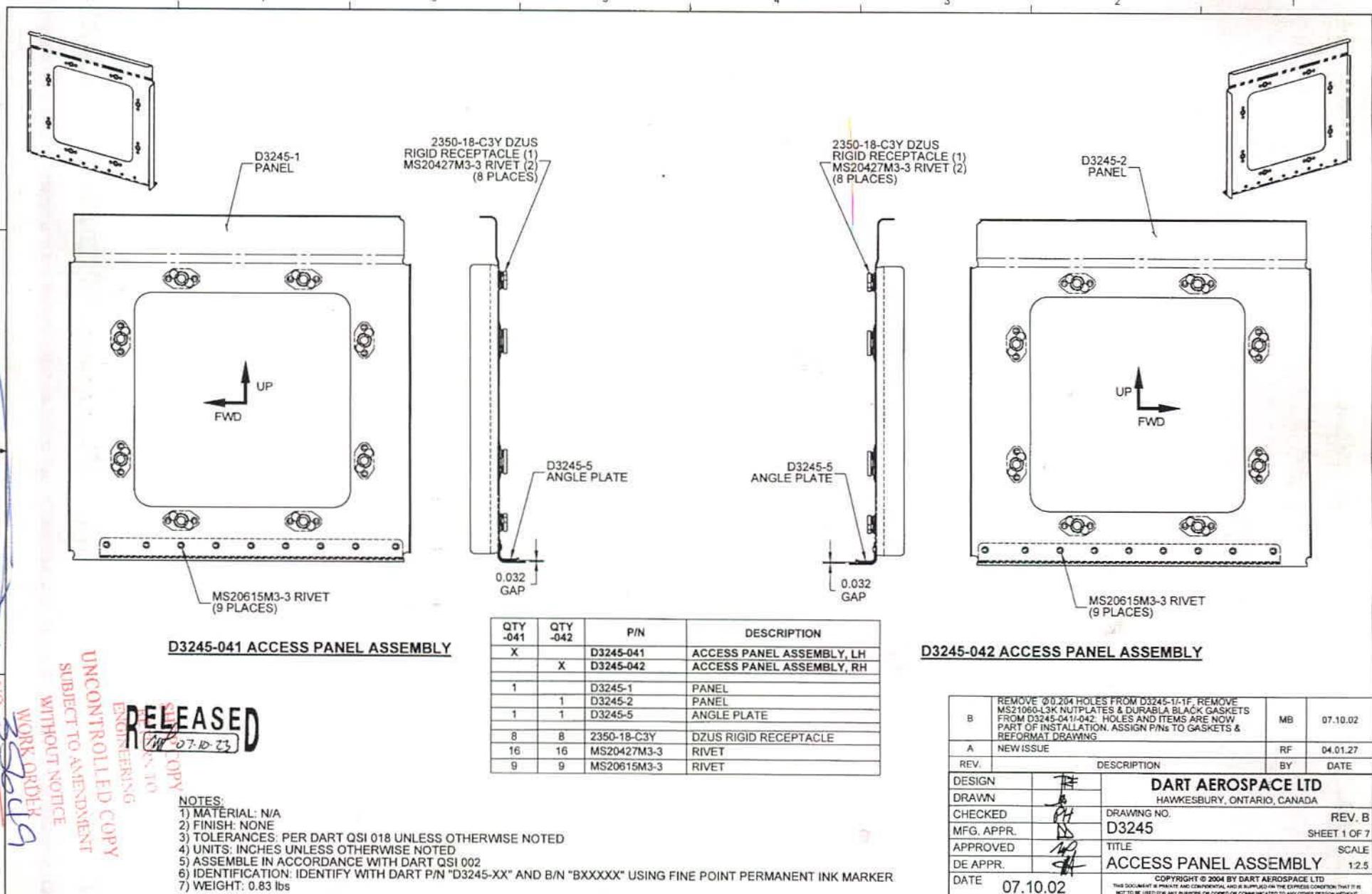
Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: ACCESS PANEL ASSEMBLY
Job Number: 35649		Part Number: D3245041
Job Number: 		
Seq. #:	Machine Or Operation:	Description:
6.0	MS20615M33 	Rivet <i>NOT for Export</i> M18235 x54 106277 AS 07/12/19 (X6) 
Comment: Qty.: 9.0000 Each(s)/Unit Total : 54.0000 Each(s) Rivet		
7.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1 
Comment: SMALL & MEDIUM FAB RESOURCE 1 Install Rivets and Nut Plates and D3245-5 angle as per Dwg D3245 <i>mf 08-01-15-08-01-09 07-12-19</i>		
8.0	QC5 	INSPECT WORK TO CURRENT STEP <i>08.01.23 (5)</i> 
Comment: INSPECT WORK TO CURRENT STEP		
9.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify with part# and batch# using fine point ink marker and Stock Location: ST 183 <i>AS 08/01/24 (X5)</i>		
10.0	QC21 	FINAL INSPECTION/W/O RELEASE  <i>08.01.25 (H)</i>
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion 		<i>200811/24 (H)</i>

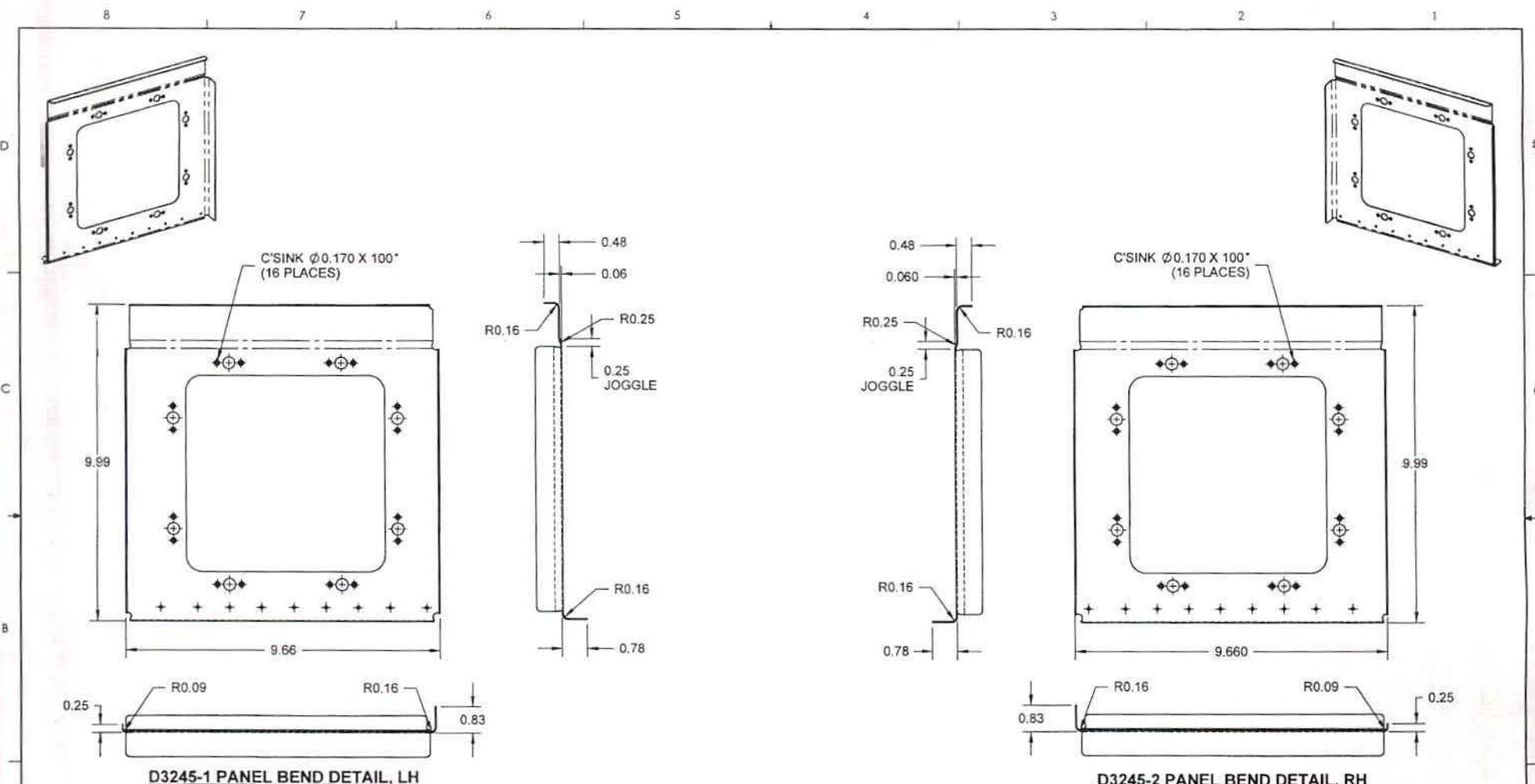
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3245-041 PAR #: 0/P Fault Category: P003 - Sm-Mal-Fnt NCR: Yes No DQA: AA Date: 08.01.25
QA: N/C Closed: DD Date: 08.01.28

NCR: 35649		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.01.09	6.0	D3245-1 Personnel was found to have dents around the installation on the MS20427M3-3 Ruts. RC the coarse sales were not correctly done. Hammering	ASME	Drill out affected rivets with a SOFT FACE HAMMER. Flatt out dents. scrapping destroy part. re-work is unacceptable.	MF 08-01-23 MF 08-01-23 MF	08-01-23	ASME	ASME

NOTE: Date & initial all entries





RELEASED
10-10-02

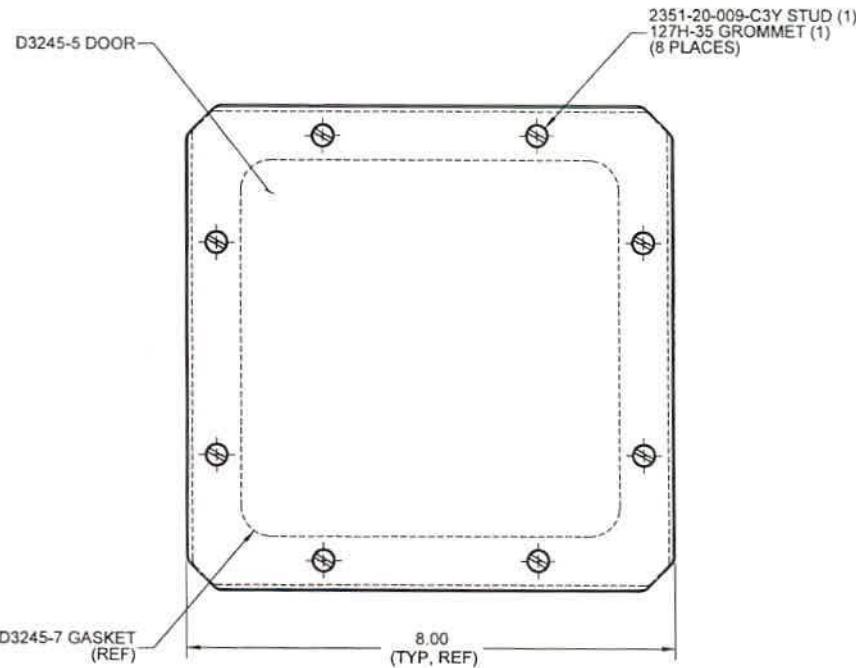
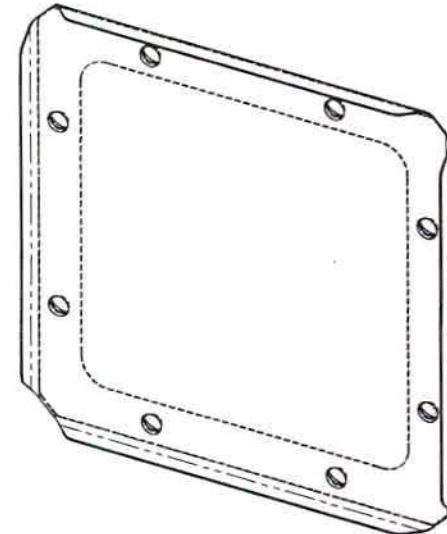
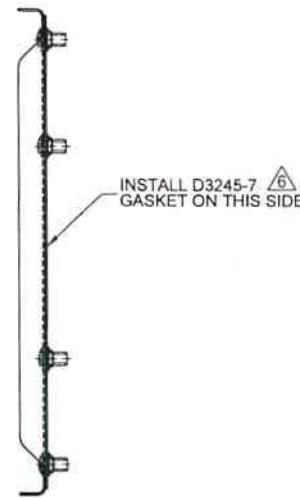
NOTES:
 1) MATERIAL: MAKE FROM D3245-1F
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.70 lbs

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WITHOUT NOTICE
WORK ORDER
87

DESIGN	77	DART AEROSPACE LTD
DRAWN	8	HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	REV. B
MFG. APPR.	DS	DRAWING NO. D3245
APPROVED	MP	SHEET 2 OF 7
DE APPR.	SH	TITLE ACCESS PANEL ASSEMBLY
DATE	07.10.02	SCALE 13

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8 7 6 5 4 3 2 1

D3245-043 DOOR ASSEMBLYD
C
B
ARELEASED
11/27/03

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSEMBLY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	2351-20-009-C3Y	STUD
8	127H-35	GROMMET

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXX" USING FINE POINT PERMANENT INK MARKER
- 9) WEIGHT: 0.73 lbs

SHOP COPY

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SUBJECT TO AN ENDMENT

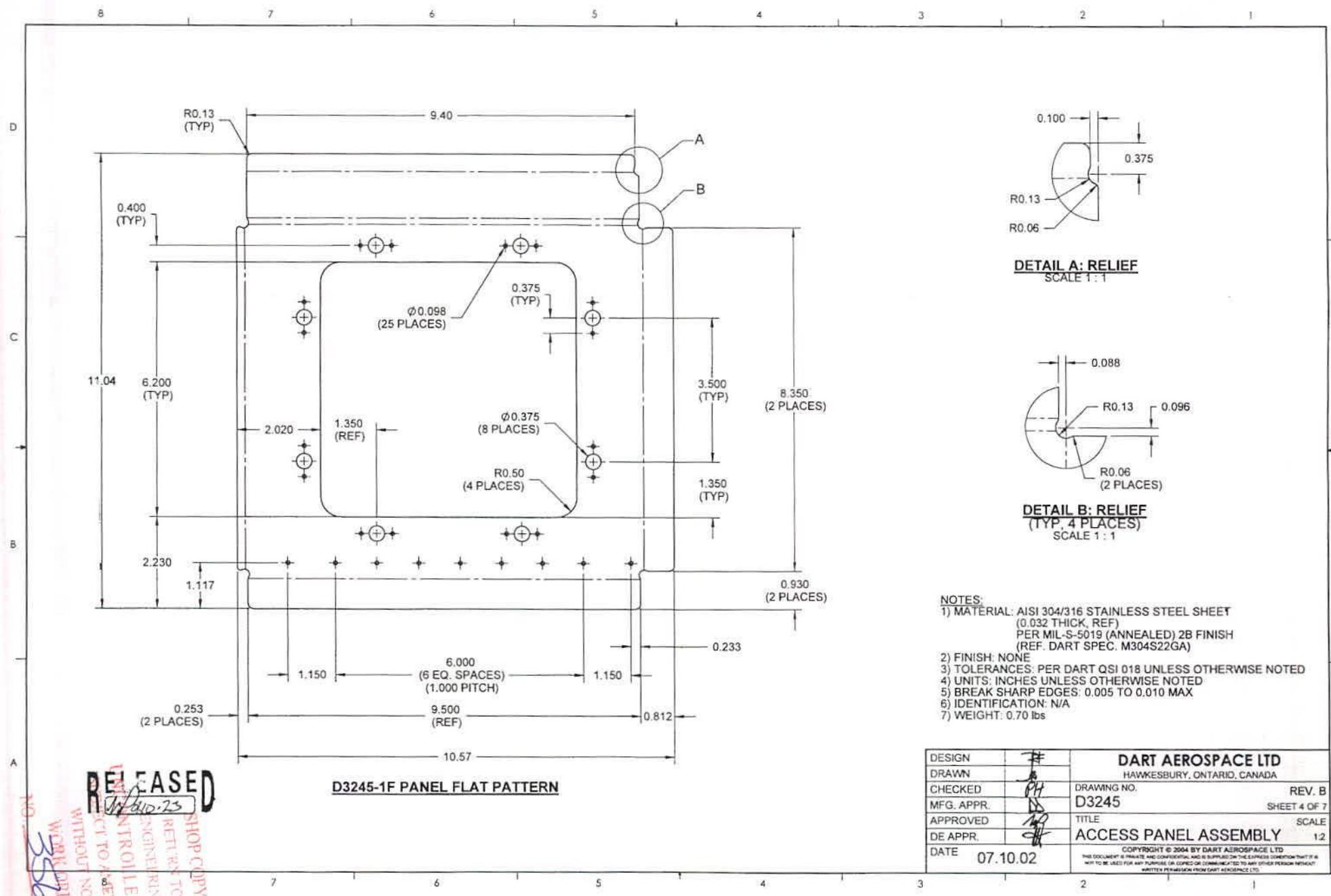
WITHOUT NOTICE

WORK ORDER

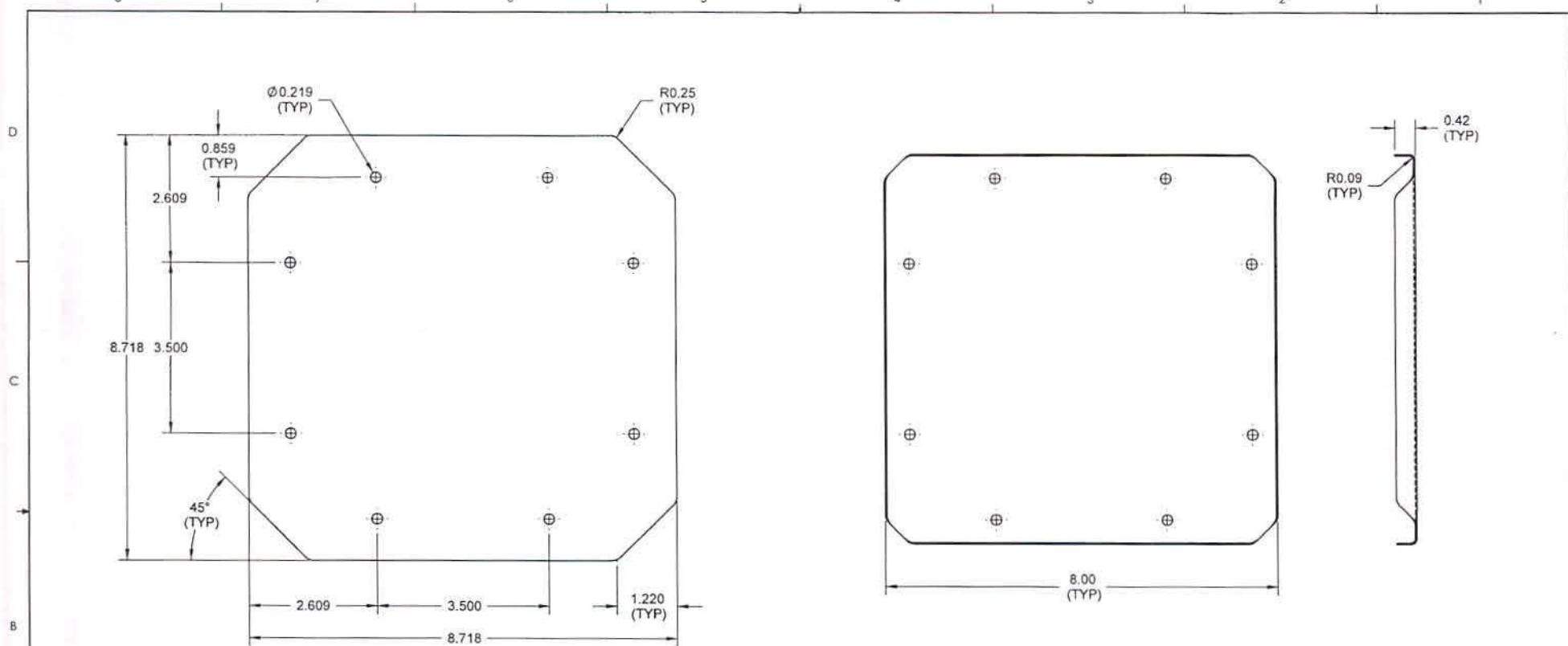
NO. 33649

DESIGN	77	DART AEROSPACE LTD
DRAWN	13	HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	DRAWING NO. D3245
MFG. APPR.	DS	REV. B
APPROVED	MP	SHEET 3 OF 7
DE APPR.	MP	TITLE ACCESS PANEL ASSEMBLY
DATE	07.10.02	SCALE 12

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8 7 6 5 4 3 2 1



D3245-3F DOOR FLAT PATTERN

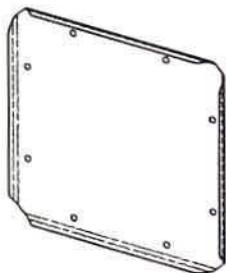
D3245-3 DOOR BENDING DETAIL

RELEASED
07-10-02

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.67 lbs

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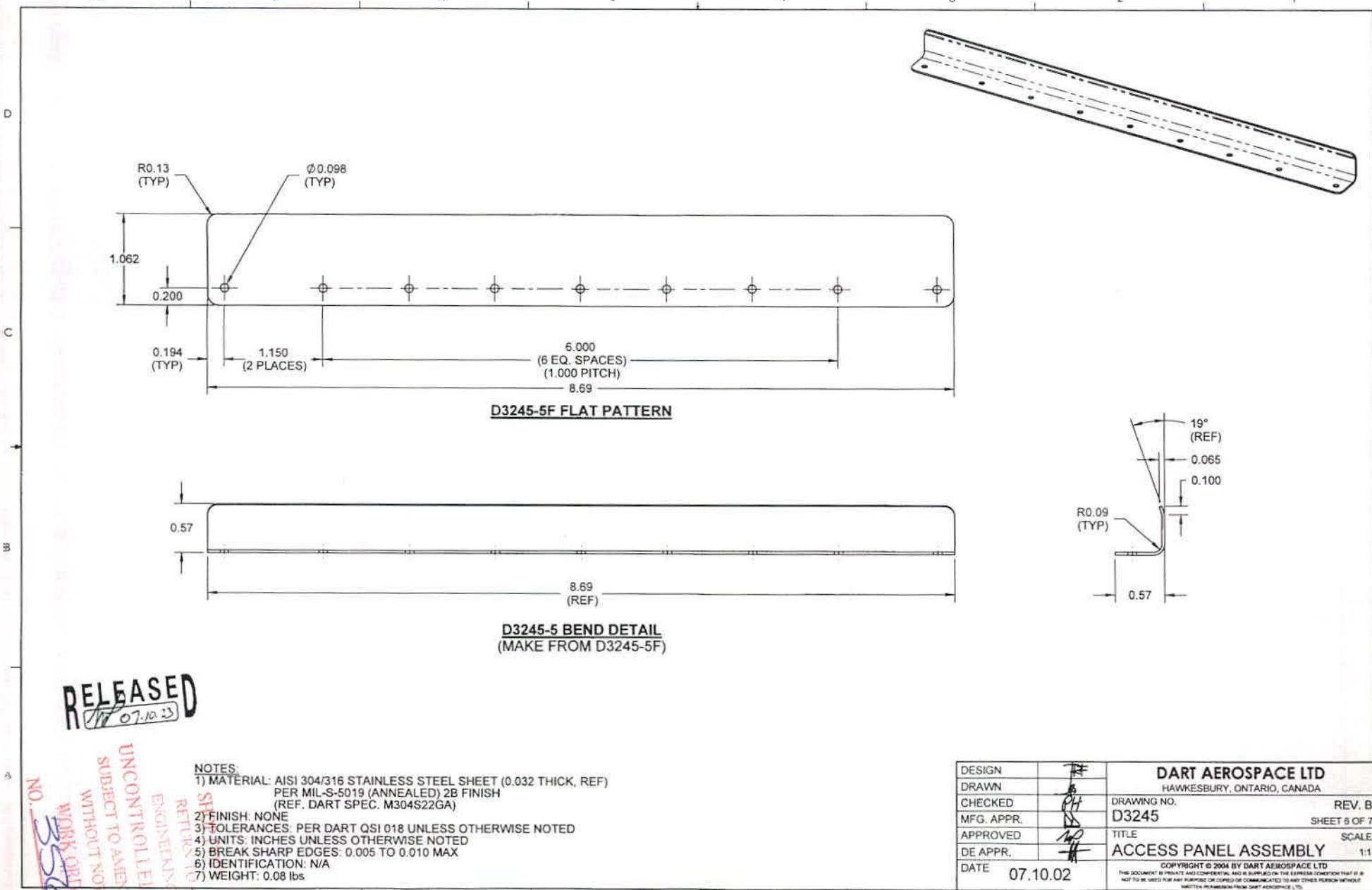


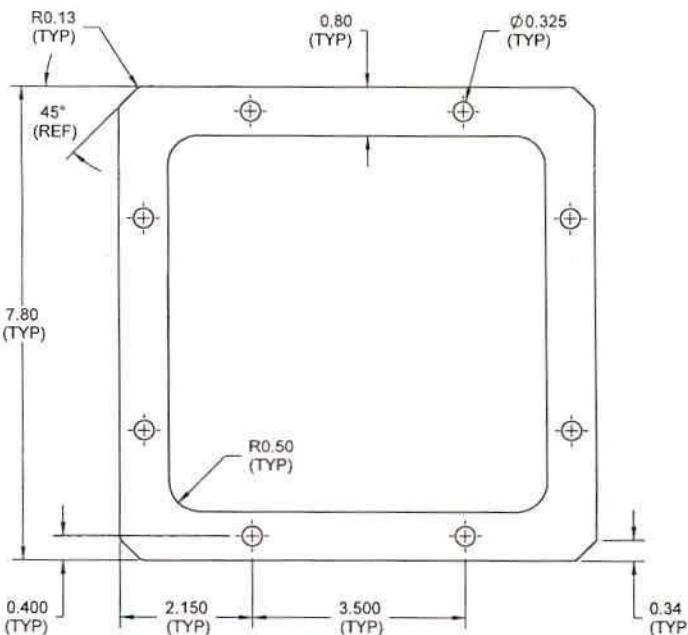
DESIGN	77	DART AEROSPACE LTD
DRAWN	8	HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	DRAWING NO.
MFG. APPR.	DS	D3245
APPROVED	MM	REV. B
DE APPR.	MM	SHEET 5 OF 7
DATE	07.10.02	SCALE
		1:2

ACCESS PANEL ASSEMBLY
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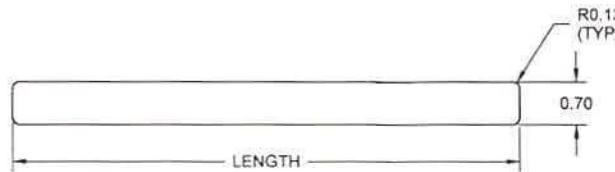
8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1





D3245-7 GASKET



D3245-X GASKET

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

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REV 07.10.02

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WORK ORDER

NOTES:

- 1) MATERIAL: DURABLA BLACK GASKET, 0.035 THICK
(PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	<i>PF</i>	DART AEROSPACE LTD	
DRAWN	<i>b</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO. D3245	
MFG. APPR.	<i>DS</i>	REV. B SHEET 7 OF 7	
APPROVED	<i>MP</i>	TITLE ACCESS PANEL ASSEMBLY	
DE APPR.	<i>CH</i>	SCALE 12	
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